

# Work Order ID 48673

July 2, 2009 3:05:06 PM



Page 1

Item ID: D3789-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 07/02/2009 Start Qty: 15.00



Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3789

Rev A

100

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Send Blanks To: Metec/Mast Precision

Machining: IP/O: Machine D3789-1 as per Dwg D3789

*Machine AS PER Folio. Rev. A*  
*Dwg Rev. A*

*SP 09/07/21*

110

0.00



Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

Packaging

QC2

09/07/21

120

0.00



QC8

QC6 Inspect dimensions to drawing

Memo

0.00

Quality Control

*3L*  
*09/07/13*

*SP 09/07/21*

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Page 2

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

09-07-13

15



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

09-07-13

X 15



QC

Memo

0.00

Quality Control

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\*\*\*Mask bearing bore prior to powder coat\*\*\*\*\*

START

TIME: 11:00 AM OVEN TEMPERATURE:

11:30 AM FINISH TIME: 320°F

09-07-13 X 15

M112148

# Work Order ID 48673

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Page 3

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Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

04-07-13

15

BK



QC

Memo

0.00

Quality Control

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- press fit D2611 bearing after powder coat  
2- stake D2611 bearing 4 places  
each side as per dwg D3789

09/07/20

15

180

QC5- Inspect part completeness to step on W/O

0.00

=> 5 or 10/100

415

φ



QC

Memo

0.00

Quality Control

**Work Order ID 48673**

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Page 4

Item ID: D3789-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 07/02/2009 Start Qty: 15.00



Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

10/9/20 (15)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/21 HJ  
mf 09-07-20

# Picklist Print

July 2, 2009 3:05:05 PM

Work Order ID: 48673

Parent Item: D3789-1RevA

Parent Item Name: Clamp



Comments:

Start Date: 07/02/2009

Required Date: 07/15/2009

Start Qty: 15.00



Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2611RevC		Manufactured	No			100	Each	31.0000	15.0000			
												
Bearing												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST 50521                      31  
46841                      31

D2423RevB1		Manufactured	No			170	f	767.4300	1.1053			
												
Lug Extrusion												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST 767.43  
43722                      219.5  
44529                      22.39  
45800                      525.54

43722

7  
8

EB09/07/20

1.7187

mk 09/07/09

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 48673
<b>Description:</b> CLAMP		<b>Part Number:</b> 3789-1
<b>Inspection Dwg:</b> D37094 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.75	+ .030	.750	/			
3.45	"	3.448	/			
.31	"	.314	/			
.40	"	.396	/			
.52	"	.528	/			
R1.470	"	1.470	/			
4.200	"	4.202	/			
1.19	"	1.190	/			
2.07	"	2.078	/			
2.63	"	2.640	/			
1.12	"	1.125	/			
.56	"	.562	/			
R.056	"	.560	/			
Ø.811	+ .0005 - .0000	.811	/			
R.75	"	.750	/			
R.50	"	.500	/			
R.250	"	.250	/			
R.030	"	.030	/			
Ø.257	+ .006 - .001	.257	/			

<b>Measured by:</b> <i>SS</i>	<b>Audited by:</b> <i>JK</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09/07/11	<b>Date:</b> 09/07/12	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

**Dart Aerospace Ltd**

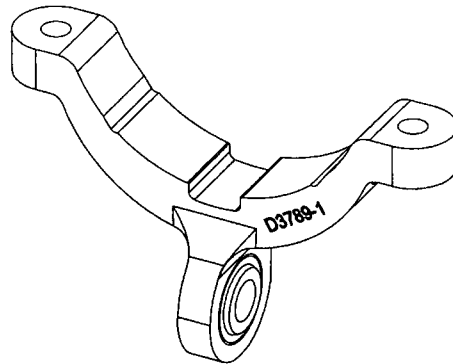
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

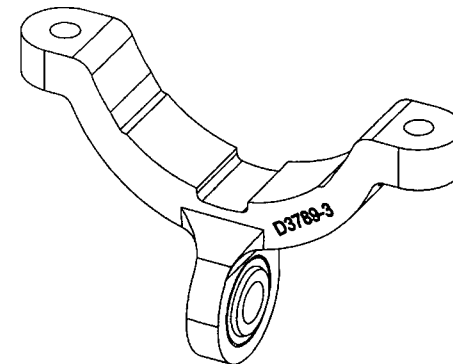
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

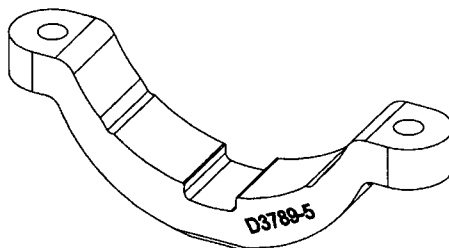
**NOTE:** Date & initial all entries



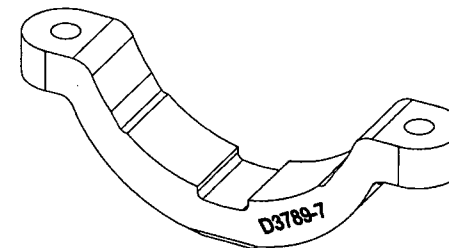
**D3789-1 CLAMP**



**D3789-3 CLAMP**



**D3789-5 CLAMP**



**D3789-7 CLAMP**

**REFERENCE ONLY**

**DEO ATTACHED**

**RELEASED**  
08/12/21

**NOTES:**

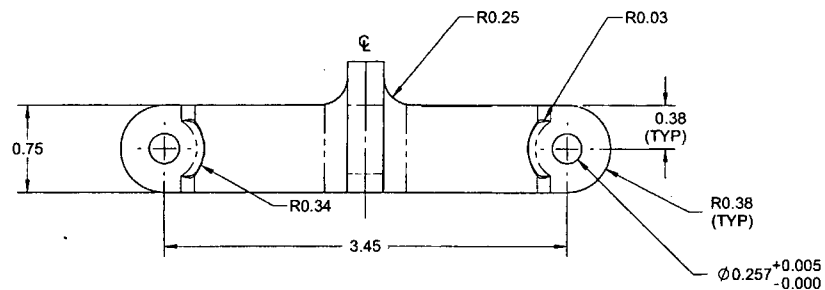
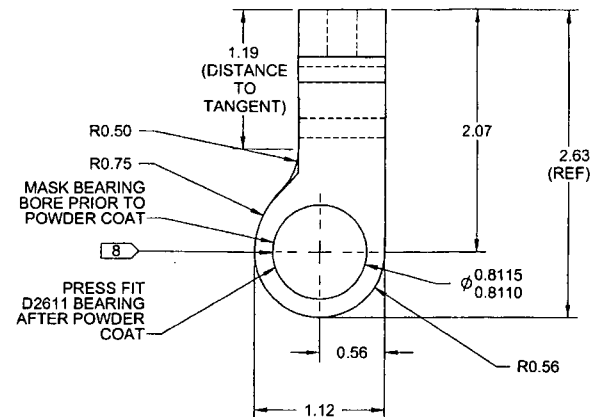
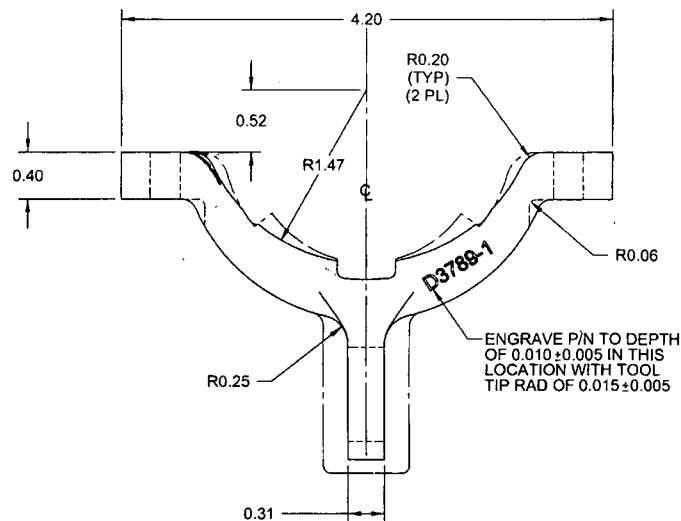
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs  
D3789-3, 0.16 lbs  
D3789-5, 0.14 lbs  
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMMETRICAL ABOUT  $\phi$

48673

A		NEW ISSUE		HS	08.05.21
REV.		DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3789</b> TITLE <b>CLAMP</b>		REV. A	
DRAWN	HS			SHEET 1 OF 5	
CHECKED				SCALE	
MFG. APPR.				NTS	
APPROVED					
DE APPR.					
DATE	08.05.21				

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**D3789-1 CLAMP**

**REFERENCE ONLY**

**DEO ATTACHED**

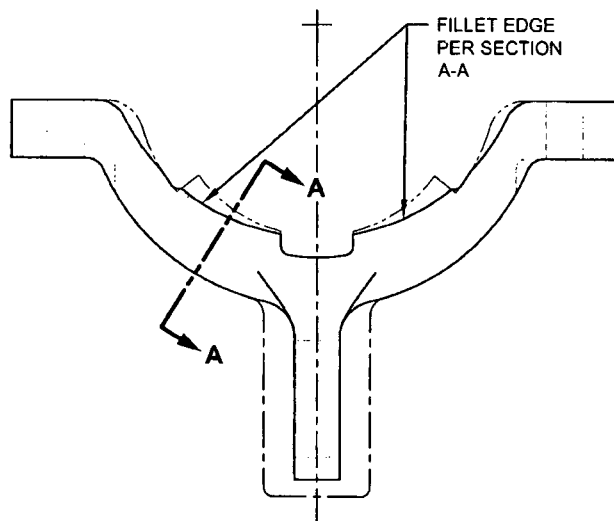
**RELEASE**  
08/12/21

48673

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.		D3789	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	08.05.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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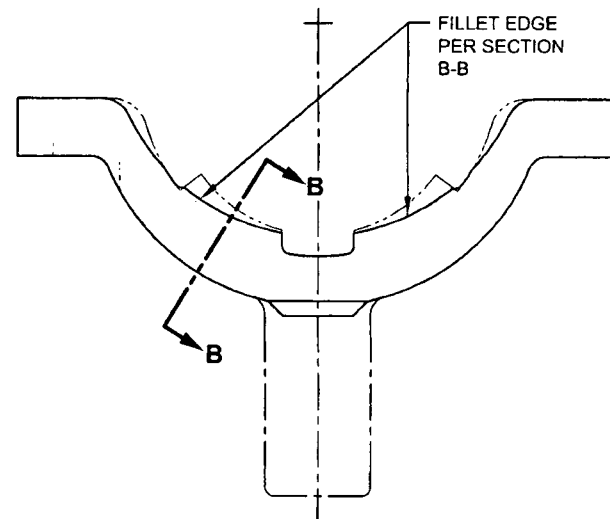
DRAWING NO. D3789	TITLE CLAMP	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3789-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23	DATE 09/04/23			

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3789-1 CLAMP

D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP

REFERENCE ONLY



R0.06 MIN - R0.10 MAX  
2PL

SECTION A-A  
SCALE 2X

SECTION B-B  
SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED  
09/05/04

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